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## Maintenance - Instructions

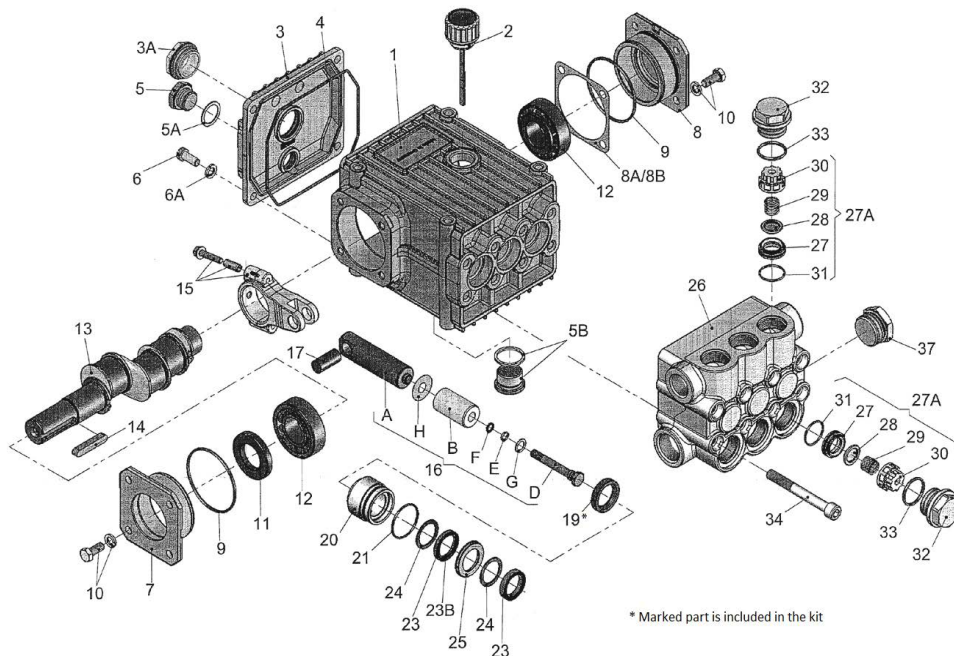
for Oil Seal Kit – BPS 17-0154  
for High Pressure Pump – Model 25/41  
from “Walter Geraetebau – Germany”

### Instructions for Oil Seal Kit for the High Pressure Pump - Model 25/41 from "Walter Geraetebau - Germany"

**NOTE:** Always take time to lubricate all metal and nonmetal parts with a light film of oil before reassembly. This step will ensure proper fit, and at the same time protecting the pumps nonmetal parts (elastomers) from cutting and scoring.

#### Kit # BPS 17-0154

Item#	Part#	Description	Qty.
27A	08408	Valve Assembly	6



### Repair Instructions

- 1) Remove oil plug (5) and drain oil. Remove crankcase cover (3). Use an 8mm allen wrench to remove the eight socket head cap screws (34). Carefully slide the valve casing (26) out over the plungers (16). Remove each seal case (20) and weep return ring (25).
- 2) Remove tension screws (16D) along with the plunger pipes (16B) and oil scrapers (16H).

**IMPORTANT!!** Before removing the conn-rods (15) make note of their position on the crankshaft so as to return them to the same location when re-assembling.

- 3) Remove screws from conn-rods (15), separate the back conn-rod half from the crankshaft and the front conn-rod half. Push front conn-rod halves as far as possible into the crosshead guide. Remove screws (10) and

pry bearing covers (7&8) gently off with a screwdriver. If present, try not to damage shim (8A/8B) and note their positions.

**IMPORTANT!!** Check the surface of each plunger (16). Damaged surfaces cause accelerated wear on the seals. Deposits of any kind must be removed from plunger surfaces. If there are deposits of any kind (e.g. lime deposits) in the valve casing, be certain the weep holes in the weep return rings (25) and valve casing (26) are not plugged.

- 4) Carefully remove crankshaft (13), making sure not to bend the front half conn-rods. Remove conn-rods with plunger bases through the rear of the crankcase (1). Pry out old oil seals (19). Pay attention to the seal direction (see point 5).
- 5) **NOTE: The orientation of the oil seals (19) is: Seal lip faces crankcase.** Press in new oil seals (19) from kit. Insert conn-rods with plunger bases, remembering their location in the crankcase. thread in the crankshaft (13). Replace bearing covers (7 & 8) together with their o-rings (9) seal (11) and bearings (12). Replace screws (10). Adjust clearance with shims (8A/8B) under bearing cover to ensure crankshaft (13) turns easily without play being felt.
- 6) Mount conn-rod halves on crankshaft remembering their position. Tighten screws (15) to 97 lb-in (11Nm). Replace the crankcase cover (3).
- 7) Replace plunger pipe (16B) with oil scraper (16H). Tighten screws (16D) with thin film of Loctite to 221-265 lb-in (25-30Nm).

**If the plunger packing seals (Kit BPS-) need to be replaced too, now is the best time for it. If not, proceed to point 8.**

- 8) Replace each seal case (20), weep return ring (25) and pressure ring (24) over plungers. Slide valve casing (26) carefully over plungers (16) and seat firmly. Replace the eight socket head cap screws (34) and tighten to 29.5 lb-ft (40Nm) in a crossing pattern (see manual).